

5/42

DART AEROSPACE LTD	Work Order:	24402
Description: 206 Step End Plate	Part Number:	D2734
Drawing: D2734 Rev. B	Qty:	23, 800

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order Check inventory of D2875, if low run at the same time	SA	05.10.03	200
2	METAL	Shear blanks: 3.035" +0.000/-0.010 X 2.90 +0.030/-0.010 Grain along 3.035" 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.063 thick. Batch: M16-154	BG	05.10.21	224 231
4	HAAS	Machine per folio D2734 Flat pattern is the same as D2875	SA	05.10.24	224 231
5	QC	Inspect Level 2	SA	05.10.24	224 231
6	QC	Inspect Level 8	BG	05.10.24	224 231
8	METAL	Form per drawing D2734	SA	05.10.25	231
9	QC	Inspect Level 5	2	05.10.25	231
10	STORES	Identify and stock	2	05.10.25	231
11	EXPEDITING	Close W/O Cost / Part , 97 suc 05/10/26 (231)	2	05/10/26	231

Rev	Date		Created By	Approved
A	98.06.02		KB	
B	00.01.11	Added note at step one, level 2, re-format	EC	
C	00.05.19	Added inspect level 8, removed P/O for powder coating	EC	
D	01.06.08	Removed Deburr	EC	EC

RELEASED

EC 01-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DS Date: 05/10/20

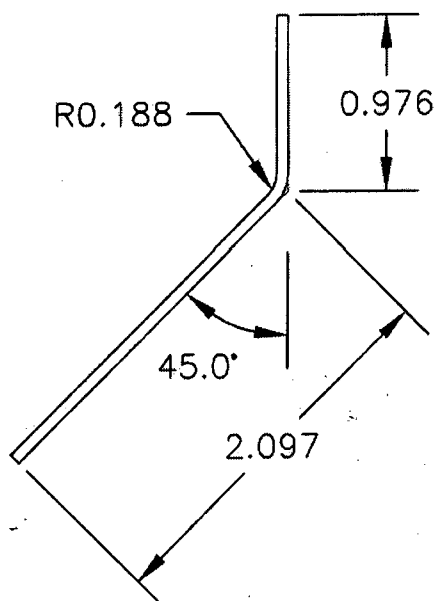
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

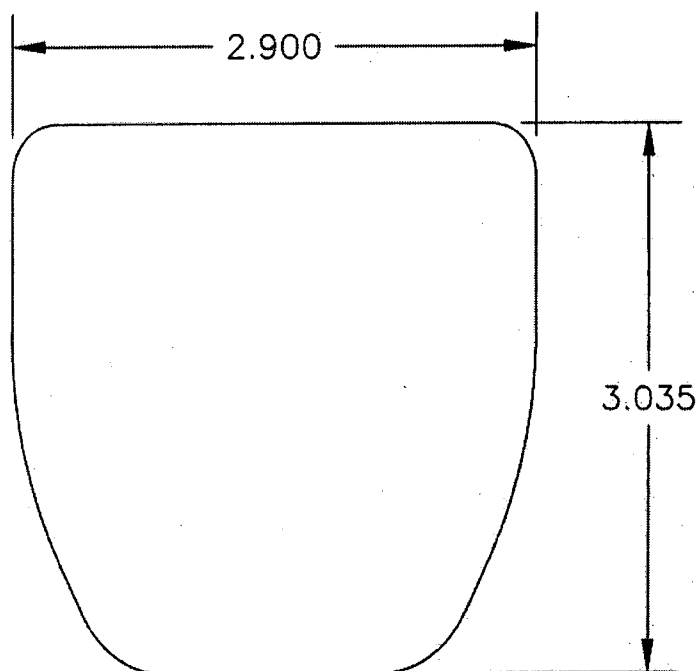


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>RA</i>	APPROVED <i>KE</i>	DRAWING NO. D2734	REV. B SHEET 1 OF 1
DATE 98.10.05		TITLE END PLATE	SCALE 1:1
A	97.12.10	NEW ISSUE	
B	98.10.05	0.976 WAS 1.016, 2.097 WAS 2.137	

RELEASED
98/10/05 KE



BEND DETAIL



FLAT PATTERN

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

NO AT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 24402

MATERIAL: 5052-H32 (QQ-A-250/8) OR
6061-T6 (QQ-A-250/11) 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 03, 2005
11:23 am

Work Order No : 0024402
Project Name : D2734
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D2734
Description : 206 Step Endplate
Manufactured : Yes
Amount Req'd : 200
Amount Done : 0
Start Date : 10-03-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00